



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2661-2
Job Sheet 212221



Part No: D2661-2

Job Qty: 2 pcs

Part Name: Saddle, RH, Fwd, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/14/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/4/20

Description:

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	2 pcs	9/3/20		0.00	0.00	HAAS - 1	DAS	10/08/20
							HAAS - 2	52	
							HAAS - 3	9-89	
							HAAS - 4	DAS	
100	HAAS 4 Axis - B4B	2 pcs	9/3/20		1.00	3.28	HAAS - 1 - B4B	52	22/08/20
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B	DAS	
110	Conventional Mill - 1 - B4B	2 pcs	9/3/20		0.00	0.13	Conventional Mill - 1 - B4B	52	21/08/20
							Conventional Mill - 2 - B4B	9-89	
120	QC 2	2 pcs	9/3/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S295121



Part: D2661-2

Job No: 212221

Serial No/Batch: S295121

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/20/20

Plex 8/14/20 9:45 AM Dart.lajeunesse.marie

				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	DAS
				QC 2 - 52	52 28/08/20
				QC 2 - 57	9-89
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	2	9/3/20	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	J.C.L. 20-08-22
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	2	9/3/20	0.00 0.05	Handfinish - 1 - 1 - B4B	ll 20-08-22
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	

				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	ML 20-9-2d
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B	2 pcs	9/4/20	0.00 0.08	Powdercoat - 1 - B4B	
M 254469				Powdercoat - 2 - B4B	
START: 11:05				Powdercoat - 3 - B4B	20-08-24
O.V.T. 300				Powdercoat - 4 - B4B	
FINISH 11:35				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	2 pcs	9/4/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	AUG 24 2020
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
170 Packaging 3-1 - Stock - B4B	2 ✓ pcs	9/4/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	AUG 25 2020
				Packaging 3 - 4 - B4B	St 401
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	2 pcs	9/4/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				Broussard	9-89
				QC 21 - SA - 9	
				QC 21 - SA - 77	
Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number MACHINE AS PER DWG AND FOLIO Descriptions: FB071 FOLIO REV: <u>AA</u> DWG REV: <u>E</u> 110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-003	Saddle Billet, 7075	2 pcs (1 ea)	90-Machining - Issue SN	S293906	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Machining - Issue SN	D6101-003	2	18	0	
Part Specifications					
Specifications could not be found.					

Plex 8/14/20 9:45 AM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 212221	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev: E				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.615	3.615			
B	0.256	0.263		0.258	0.259			
C	0.315	0.322		0.316	0.316			
D	2.495	2.505		2.499	2.499			
E	1.674	1.684		1.678	1.678			
F	1.357	1.367		1.361	1.361			
G	0.100	0.140		0.122	0.122			
H	0.210	0.230		0.223	0.222			
I	0.615	0.685		0.670	0.670			
J	2.470	2.510		2.490	2.490			
K	1.313	1.343		1.325	1.324			
L	0.178	0.198		0.188	0.188			
M	0.470	0.530		0.500	0.500			
N	1.125	1.145		1.135	1.135			
O	0.100	0.180		0.140	0.140			
P	0.100	0.140		0.132	0.135			
Q	0.240	0.260		0.259	0.250			
R	0.677	0.697		0.687	0.687			
S	0.100	0.140		0.128	0.129			
T	1.565	1.585		1.575	1.575			
U	0.540	0.560		0.550	0.549			
V	0.912	0.932		0.920	0.920			
W	0.787	0.807		0.798	0.798			
X	5.990	6.010		6.001	6.001			
Y	4.995	5.005		5.000	5.000			
Z	0.490	0.510		0.500	0.499			
AA	0.312	0.319		0.313	0.313			
AB	0.990	1.010		1.001	1.001			
AC	1.245	1.255		1.249	1.249			
AD	0.490	0.510		0.500	0.504			
AE	3.745	3.755		3.749	3.749			
AF	0.235	0.240		0.238	0.238			
AG	0.510	0.515		0.512	0.512			
AH	0.100	0.120		0.113	0.113			

DAS Accept/Reject

Measured by: 52	Date: 9/08/20
Audited by: J.C.-L.	Date: 20-08-22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					